

Date: Tuesday, 10/30/2007 2:50:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INLET ADAPTER
Job Number	: 35453		
Estimate Number	: 12174		
P.O. Number	: <i>NIA</i>	Part Number	: D3478041
This Issue	: 10/30/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D3478 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 34069	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/15/2007 Qty: 6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev. A New Issue 06-02-03 JLM Est Rev. B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34783	TUBE
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3478-3	Tube	<i>107.10.30</i>
---	---------	------	------------------

*1535236**mf*

2.0	D34781	FLANGE
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3478-1	Flange	<i>07-11-01</i>
---	---------	--------	-----------------

*1334400**mf**07-11-01*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3478

2-Spot Weld as per Dwg D3478 and Dart QSI 018

*mf**07-11-01*

4.0	QC11	VISUAL INSPECTION OF SPOT WELDING
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Comment: VISUAL INSPECTION OF SPOT WELDING

813 07-11-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/11/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:50:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET ADAPTER

Job Number: 35453

Part Number: D3478041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 27/11/07

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: 153

2/11/180

(6x)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/11/102

Job Completion



4 67.11.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

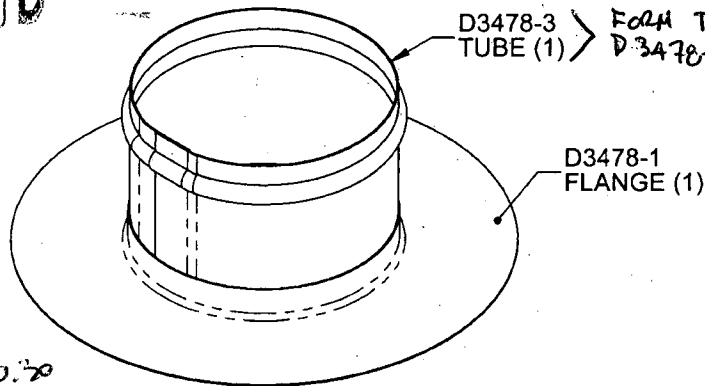
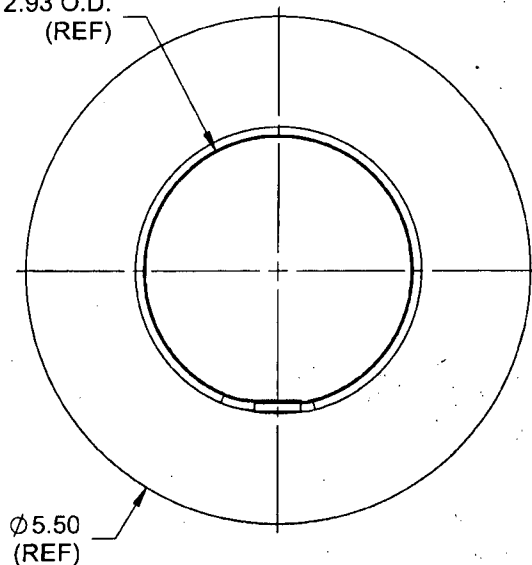
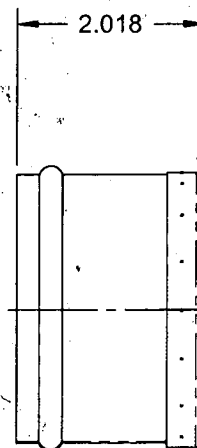
NOTE: Date & initial all entries

DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3478	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2
A	05.12.08	NEW ISSUE	
B	06.05.16	REDESIGN D3478-5, ADD D3478-7, D3478-9S/-9	

RELEASED
06.05.16 H**UNDER REVIEW**

C2.04.02.13

Dirt + Manufacturing
ChangeOK PER REV.B
+ MARK UPS.Ø2.93 O.D.
(REF)Ø5.50
(REF)Ø0.50
(18)SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 35453**D3478-041 AIR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3478-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY	P/N	DESCRIPTION
1	D3478-041	AIR INLET ADAPTER
1	D3478-1	FLANGE
1	D3478-3	TUBE

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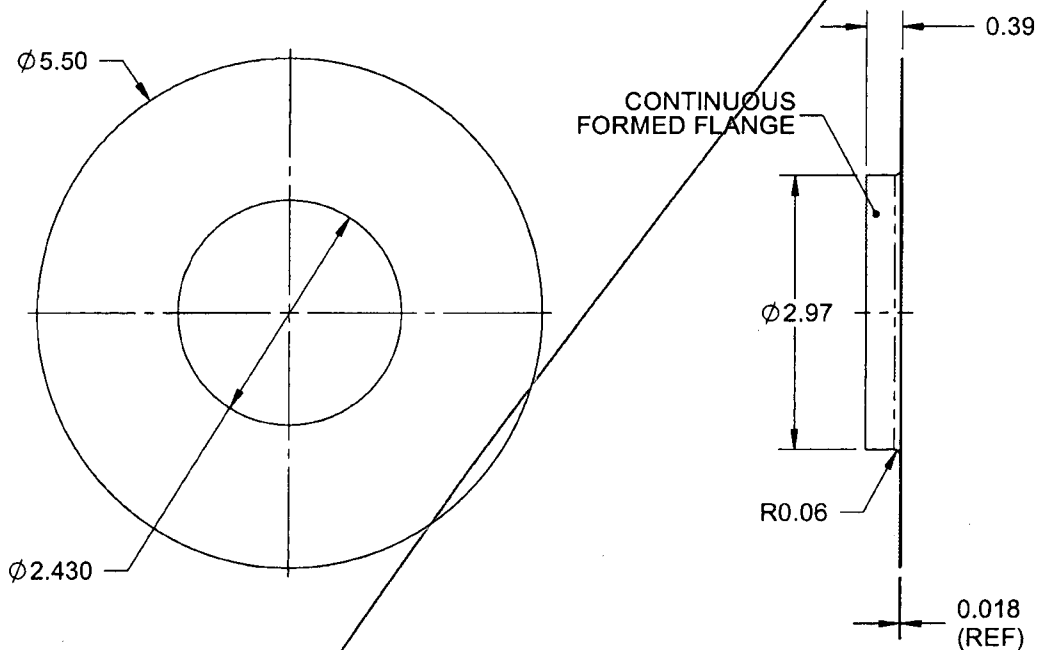


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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06-05-16 #

UNDER REVIEW

C2.04.02.13
DIP + MANUFACTURING
CHANGES



**D3478-1F FLANGE
FLAT PATTERN**

**D3478-1
FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

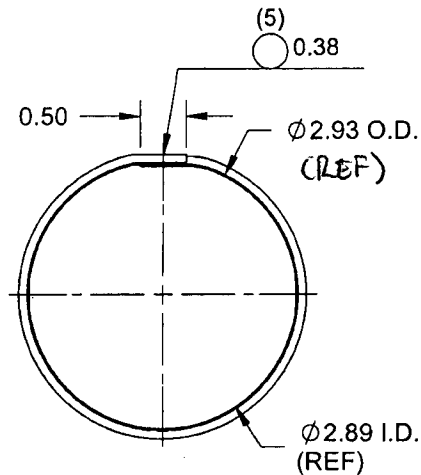
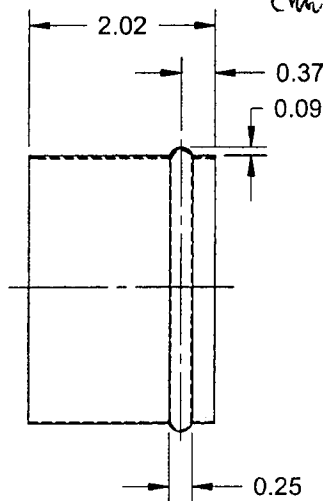
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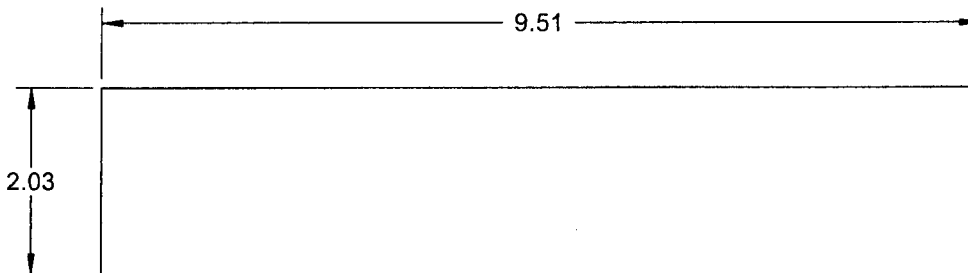
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16 *#***UNDER REVIEW**~~02.04.16 *B*~~~~DIM + MANUFACTURING
CHECKS~~FORM TO FIT
D3478-1
FLANGE.

07.10.30

D3478-3 TUBE**D3478-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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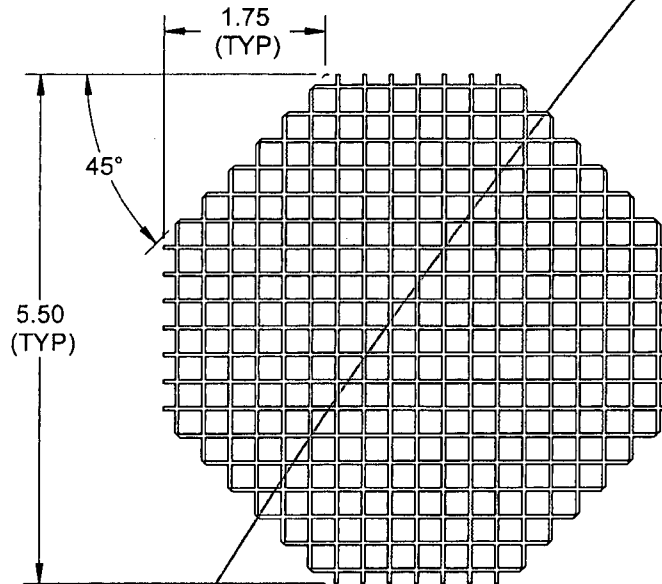
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16 #**UNDER REVIEW**

02.06.16

Dir & Manufacturing
(White)**D3478-5 SCREEN****NOTES:**

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING, ϕ 0.047" WIRE
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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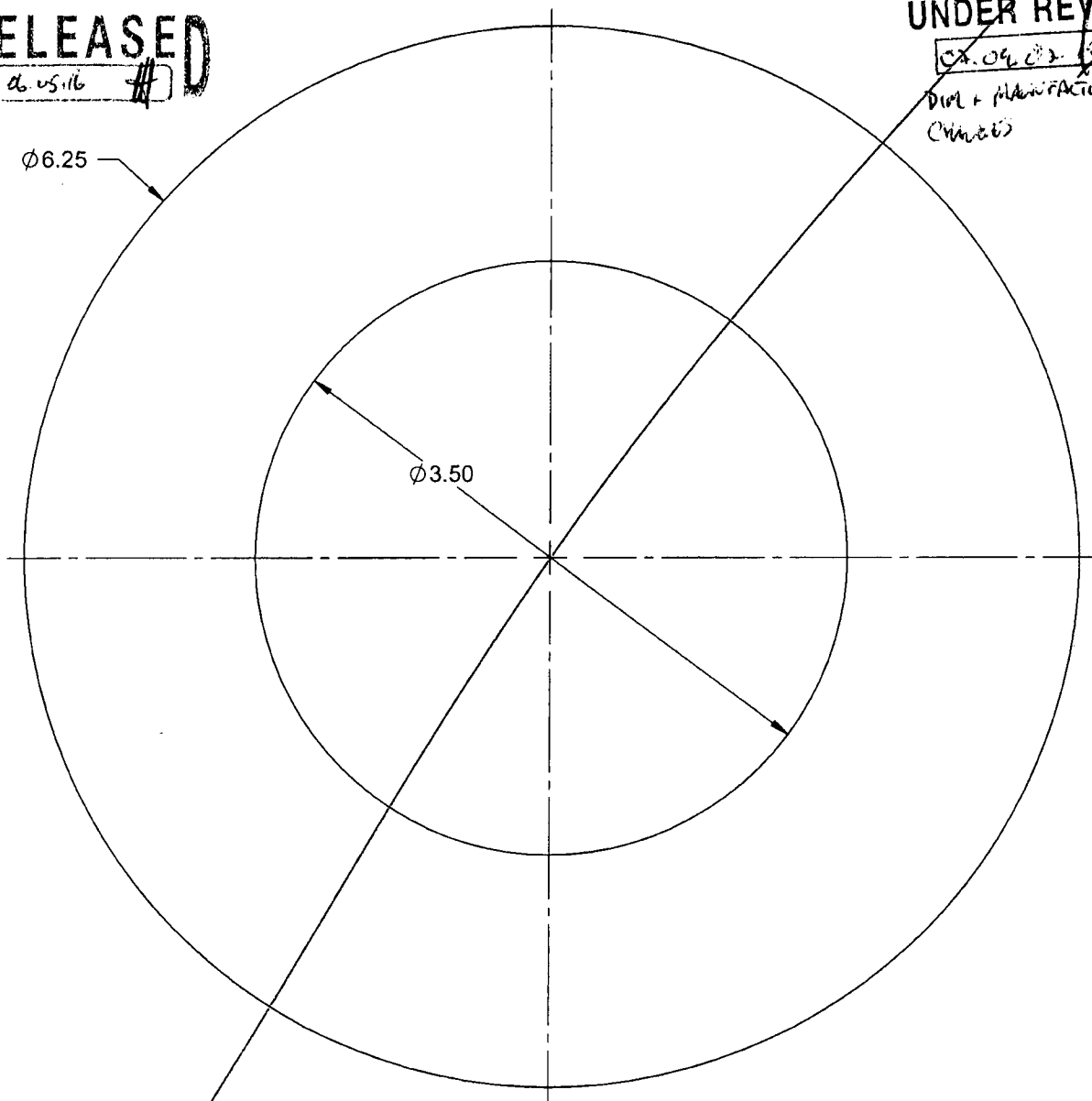


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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:1

RELEASED
06.05.16 *H*

UNDER REVIEW

04.04.03 *H*
Dim + MANUFACTURING
CHANG



D3478-7 INLET GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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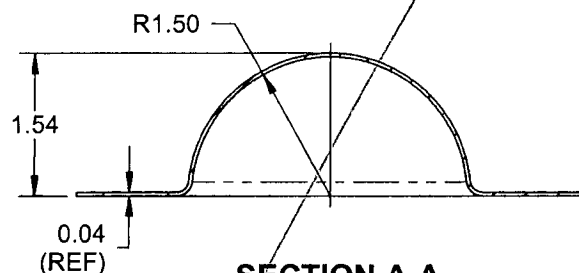
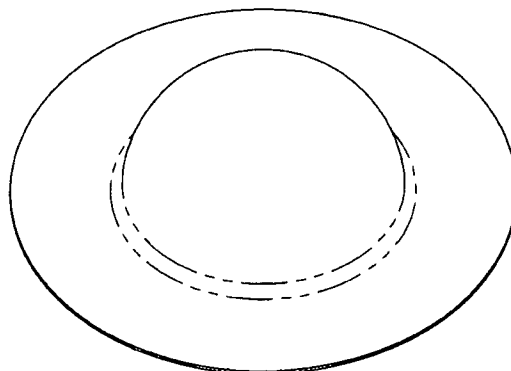
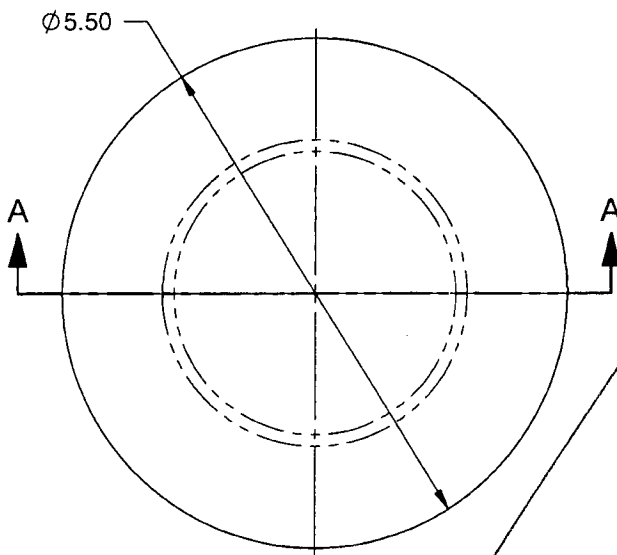
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DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16

UNDER REVIEW

02.04.02

Dim + Manufacturing
Changes



SECTION A-A

D3478-9S AIR INLET SCOOP, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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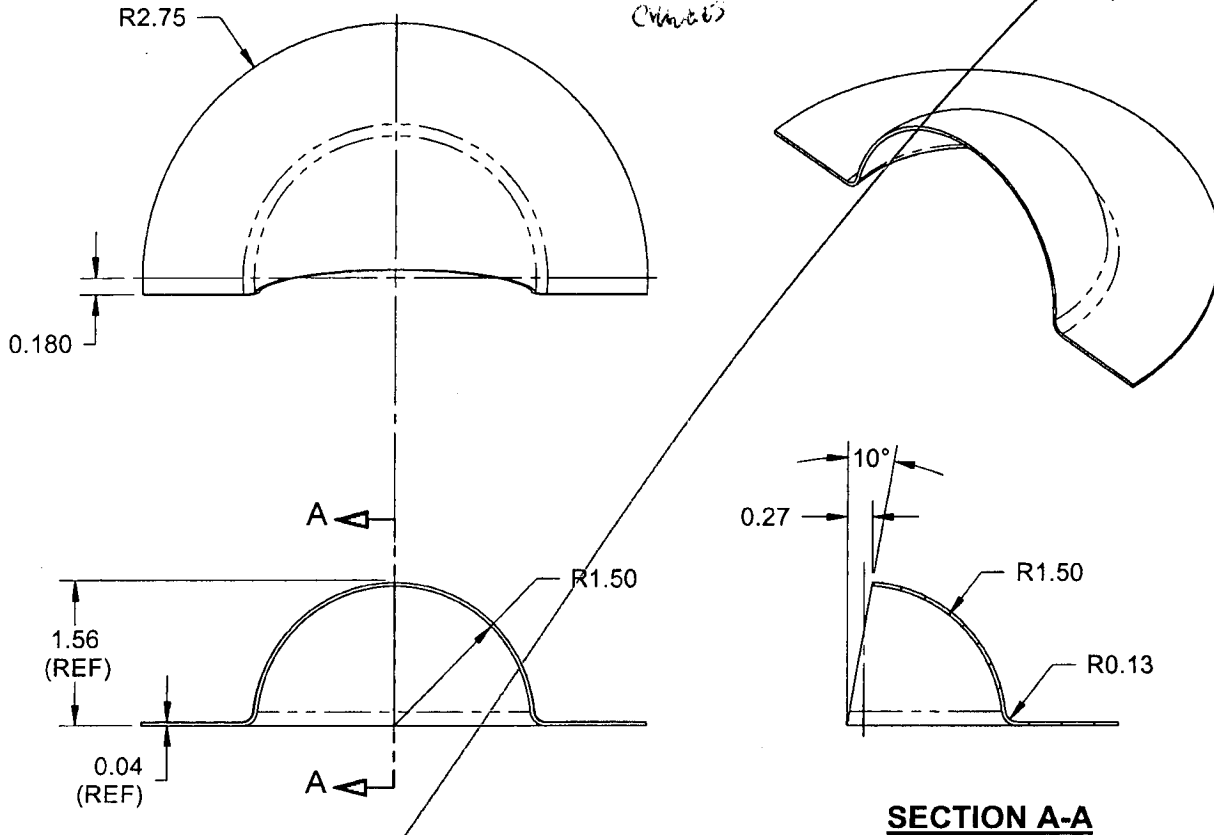
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DATE 06.05.16	TITLE AIR INLET ADAPTER		SCALE 1:2

UNDER REVIEW

02.04.02

Dim & planification
checked

RELEASED
06.05.16



D3478-9 INLET SCOOP

NOTES:

- 1) MATERIAL: MAKE FROM D3478-9S
- 2) IDENTIFY WITH DART P/N D3478-9 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 38

EMPLOYEE: Melanie Fautour

PART NUMBER: D3478-041

JOB NUMBER: B35453

MATERIAL TYPE: 30-11

MATERIAL THICKNESS: 0.18

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/11/01

QUALIFIER: SB